

# Work Order ID 78855

**\*78855\***

Page 1

January-16-12 2:18:18 PM

Item ID: D407-802-018

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Passenger Door Opener Installation, RH

Stop **\*NS2\***

Start Date: 16/01/2012 Start Qty: 3.00

**\*3\***

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 3.00

**\*3\***

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 12/01/16 Tooling:

Run Start **\*NR1\***

QC: Date: SPC (Y/N):

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D407-802-1	A

100	DOCUMENT CONTROL	0.00							
<b>*100*</b>									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D407-802-018 CHG001								

105	Pick Kit	0.00							
<b>*105*</b>									
Packaging	Memo	0.00							
Packaging									

110	QC4- 100% Inspect kits for completeness	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									

W/ 12 01 26 (3)

HA for M.L.J 12-1-18 (3)

12/1/18

W/ 12 01 26 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Item ID: D407-802-018

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Passenger Door Opener Installation, RH

Stop

**\*NS2\***

Start Date: 16/01/2012 Start Qty: 3.00

**\*3\***

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 3.00

**\*3\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

0.00

**\*120\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD407-802-018

Location:

PPP rev: A

130

QC21- Final Inspection - Work Order Release

0.00

**\*130\***

QC

Memo

0.00

Quality Control

12/1/26 (3)

12/1/26

MF  
12-01-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

January-16-12 2:18:22 PM

Page 1

Work Order ID: 78855

**\*78855\***

Parent Item: D407-802-018

**\*D407-802-018\***

Parent Item Name: Passenger Door Opener Installation, RH

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 10.09.27 new issue DD verf:EC  
10.12.03 as per dwg rev.A DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3552-17  
**\*D3552-17\***  
Door Prop

Manufactured No 105 Each 21.0000

1  
\*\*

Location Loc Qty Loc Code

ST272 11

64338 4

65120 7

ST276 10

69670 10

3

D3622-5  
**\*D3622-5\***  
Ball Stud

Manufactured No 105 Each 24.0000

1  
\*\*

Location Loc Qty Loc Code

ST058 24

65087 4

76963 20

3

D4108-3  
**\*D4108-3\***  
Door Doubler, Right

Manufactured No 105 Each 4.0000

1  
\*\*

Location Loc Qty Loc Code

st128 4

64485 4

3

3  
12/1/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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January-16-12 2:18:22 PM

Page 2

Work Order ID: 78855

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Parent Item: D407-802-018

\*D407-802-018\*

Parent Item Name: Passenger Door Opener Installation, RH

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 3.00

Required Qty: 3.00

D4108-5

Manufactured No

105 Each

3.0000

\*D4108-5\*

Small Right Door Doubler

\*\*

## Location

## Loc Qty

## Loc Code

st128

3

62303

1

64486

2

Manufactured No

105 Each

5.0000

D4108-11

\*D4108-11\*

Template

\*\*

## Location

## Loc Qty

## Loc Code

st128

5

64488

5

Manufactured No

105 Each

0.0000

D4108-047

\*D4108-047\*

Sill Doubler Assembly

CR3523-4-02

Purchased No

105 Each

455.0000

\*CR3523-4-02\*

RIVET

\*\*

## Location

## Loc Qty

## Loc Code

ST313

455

116391

100

116893

3

116915

1

117946

1

117978

200

118686

50

119717

100

January-16-12 2:18:22 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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January-16-12 2:18:22 PM

Page 3

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Parent Item: D407-802-018

**\*D407-802-018\***

Parent Item Name: Passenger Door Opener Installation, RH

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 3.00

Required Qty: 3.00

CR3523-4-4

Purchased

No

105

Each

104.0000

**\*CR3523-4-4\***

Rivet

\*\*

## Location

## Loc Qty

## Loc Code

ST314

104

115768

4

119717

100

MS20426AD4-6

Purchased

No

105

Each

1,349.000

**\*MS20426AD4-6\***

Rivet

\*\*

## Location

## Loc Qty

## Loc Code

ST317

1349

110139

207

117505

142

119436

1000

MS21073L5

Purchased

No

105

Each

57.0000

**\*MS21073L5\***

nut plate

\*\*

## Location

## Loc Qty

## Loc Code

ST302

57

117395

57

MS27039C1-27

Purchased

No

105

Each

31.0000

**\*MS27039C1-27\***

Screw

\*\*

## Location

## Loc Qty

## Loc Code

ST293

31

115768

31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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January-16-12 2:18:22 PM

Page 4

Work Order ID: 78855

\*78855\*

Parent Item: D407-802-018

\*D407-802-018\*

Parent Item Name: Passenger Door Opener Installation, RH

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 3.00

Required Qty: 3.00

NAS1149C0332R

Purchased

No

105

Each

2,888.000

2

\*\*

\*NAS1149C0332R\*

Washer

## Location

## Loc Qty

## Loc Code

ST297

2888

118354

705

119124

12

119736

2171

NAS1149C1165R

Purchased

No

105

Each

81.0000

2

\*\*

\*NAS1149C1165R\*

Washer

## Location

## Loc Qty

## Loc Code

ST296

81

115768

81

NAS1149C0532R

Purchased

No

105

Each

617.0000

6

\*\*

\*NAS1149C0532R\*

WASHER

## Location

## Loc Qty

## Loc Code

ST297

617

116373

1

116513

53

118384

163

119736

400

NAS1149C0563R

Purchased

No

105

Each

294.0000

6

\*\*

\*NAS1149C0563R\*

Washer

## Location

## Loc Qty

## Loc Code

ST297

294

116391

94

117460

200

January-16-12 2:18:22 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D407-802-1  
Page 27 of 28

5.3 D407-802-017/-018 Passenger Door Opener Kits

Qty -017	Qty -018	Part Number	Description
		D407-802-017	PASSENGER DOOR OPENER KIT, LH
		D407-802-018	PASSENGER DOOR OPENER KIT, RH
1	1	D3552-17	DOOR PROP
1	1	D3622-5	BALL STUD
1		D4108-1	DOOR DOUBLER, LEFT
	1	D4108-3	DOOR DOUBLER, RIGHT
	1	D4108-5	SMALL RIGHT DOOR DOUBLER
	1	D4108-11	TEMPLATE
	1	D4108-047	SILL DOUBLER ASSEMBLY
1		D4108-049	LITTER DOOR FITTING ASSEMBLY
	19	CR3523-4-2	RIVET
21		CR3523-4-3	RIVET
	4	CR3523-4-4	RIVET
2		MS20426AD4-5	RIVET
	2	MS20426AD4-6	RIVET
1	1	MS21073L5	ANCHOR NUT
3		MS21209-F1-15	HELICOIL
3		MS27039C1-06	SCREW
1		MS27039C1-09	SCREW
2	2	MS27039C1-27	SCREW
2	2	NAS1149C0332R	WASHER
2	2	NAS1149C1165R	WASHER
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

5.4 D407-802-019 Baggage Door Opener Kit, Composite

Qty -019	Part Number	Description
	D407-802-019	BAGGAGE DOOR OPENER KIT, COMPOSITE
1	D3552-19	DOOR PROP
1	D4109-041	DOUBLER ASSEMBLY, BULKHEAD
1	D4109-043	DOUBLER ASSEMBLY
3	80-004-2-6	INSERT
4	MS27039C1-05	SCREW
3	MS27039C1-06	SCREW
7	NAS1149C0363R	WASHER
4	NAS1836-3-08M	INSERT

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Revision: A  
Date: 10.10.13